

Wednesday, 9/26/2007 7:56:03 AM  
Kim Johnston

# Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 34873-1  
Estimate Number : 10033  
Part Number :  
This Issue : 9/26/2007 S.O. No. :  
Print Rev. : NC  
First Issue : 1/1 Type : MACHINED PARTS  
Previous Run : 34644  
Written By :  
Checked & Approved By :  
Comment : Est. A 01.05.04 New Issue EC

Drawing Name : SADDLE BILLET

Part Number : D6101003  
Drawing Number : D610 REV A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 10/26/2007

Qty: 300 Umt: Each

Additional Product

Seq #	Machine Or Operation:	Description :
10	PURCHASING	
<p>Comment: PURCHASING Issue P/O: 4655 a) Description: Aluminum billet b) 7.875" x 6.250" x 2.00" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.875" length e) Material: 7075-T7351 (QQ-A-250/12) f) Material certification required</p> <p>0207/09/24</p> <p>(300)</p>		
20	D6101003P	7075-T7351 2X6.25X7.875
<p>Comment: Qty: 1.0000 Each(s)/Unit Total: 300.0000 Each(s) 7075-T7351 2X6.25X7.875</p>		
30	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Receive &amp; Inspect For Transit Damage Ensure material certification is attached</p> <p>AS 08/09/24 XSO</p>		
40	QC6	DIMENSIONAL CHECK
<p>Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D6101</p> <p>8 08/10/24 (750)</p>		



Date: Wednesday, 9/26/2007 7:56:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BIL .ET

Job Number: 34873

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

50

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

60

QC21



FINAL INSPECTION/W/O RELEASE



08/10/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-24



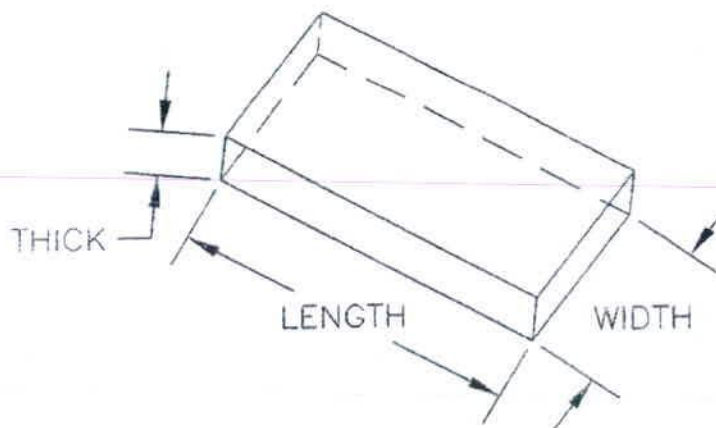




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>AS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BULLET, 7075	SCALE N.T.S.
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
21.04.23



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

SHOW  
RETURN  
UNCONTROLLED  
SUBJECT TO APPROVAL  
WITHOUT  
WORK  
NO. 34873

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

4685

71037 200 50

MANITOULIN

ETEUR-PURCHASING AGENT  
INDA LACELLE

TELEPHONE

613 632-3334

H/C TAXE

NO. COM ORD

1

REGION LIVRAISON-DEL ZONE

C/C

F.A.B.-F.O.B.

PREPAID

BILL

NO. FEVILLE/EMBALLAGE-B/L NUMBER

IE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

INFORMATION CREDIT-CREDIT INFORMATION

ROUTE

01-NL-10/13

30-NL-10/16

31-NL-10/21

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS/LIVRAISON-DELIVERY  
NQ-J85222

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.0000 PLATE 7075-T7351 ALUM 6.25" X 6.00"

BLACK W/RED STRIPE

QTE/UNITE COM.-ORDERED

50 PCS

PCS/PO COM.-ORD.

POIDS COM.-WT. ORDERED

379

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

379

CERTIFICATE OF CONFORMANCE

A.M. Castle & Co. certifies that the material(s) supplied  
under this document will meet and conform to the  
specifications of the product(s) described hereon.

A.M. Castle &amp; Co. (Canada) Inc.

INSTRUCTIONS

TOL: +.030/- .000

THICKNESS TOL.: +.030/- .000

GRAIN TO RUN ALONG 6.00"

PRIOR DIST/ORD: 01 673055

COULÉE INFO-HEAT INFO QTE-QTY

440545 A2 (4)

441611 A1 (9)

INSTRUCTIONS (CONT'D.)

✓ 50x6.25x6.00

FORME-SHAPE

I.A.C.

6857

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE  
INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE  
SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF  
MATERIAL AND, IF CHECKED, TEST REPORTS.

DESCRIPTION - ITEM 2

2.0000 PLATE 7075-T7351 ALUM 6.25" X 7.875"

BLACK W/RED STRIPE

QTE/UNITE COM.-ORDERED

50 PCS

PCS/PO COM.-ORD.

POIDS COM.-WT. ORDERED

498

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

600/498

TERMS AND CONDITIONS  
OF SALESEE DISCLAIMERS AND LIMITATIONS  
ON THE REVERSE SIDE

INSTRUCTIONS

TOL: +.030/- .000

THICKNESS TOL.: +.030/- .000

GRAIN TO RUN ALONG 7.875"

PRIOR DIST/ORD: 01 673055

COULÉE INFO-HEAT INFO QTE-QTY

440545 A2

INSTRUCTIONS (CONT'D.)

✓ 50x6.25x7.875

FORME-SHAPE

I.A.C.

6857

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED  
ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY  
RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF  
SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN  
10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

2 BOXES

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCS/PO COM.-ORD.

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-  
DATE RECEIVED

FEVILLE D'EMBALLAGE - PACKING SLIP





## SHIP TO:

A M CASTLE & CO  
14001 ORANGE AVE  
P.O. BOX 1402  
PARAMOUNT, CA 90723

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4134429

## SOLD TO:

AM CASTLE & CO- SOLD TO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 02-30434		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 101320/23		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1068979	LINE ITEM: 1	SHIP DATE: 6-JUL-2008		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE		
WEIGHT SHIPPED: 8620 LB	QUANTITY: 6 PCS EST.		B/L NUMBER: 2018511		GAUGE: 2.0000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN

### Certified Specifications

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 424354A9 Cast 169

Drop 38

Ingot 4

S  
08/10/24

(ASTM E8/B557)

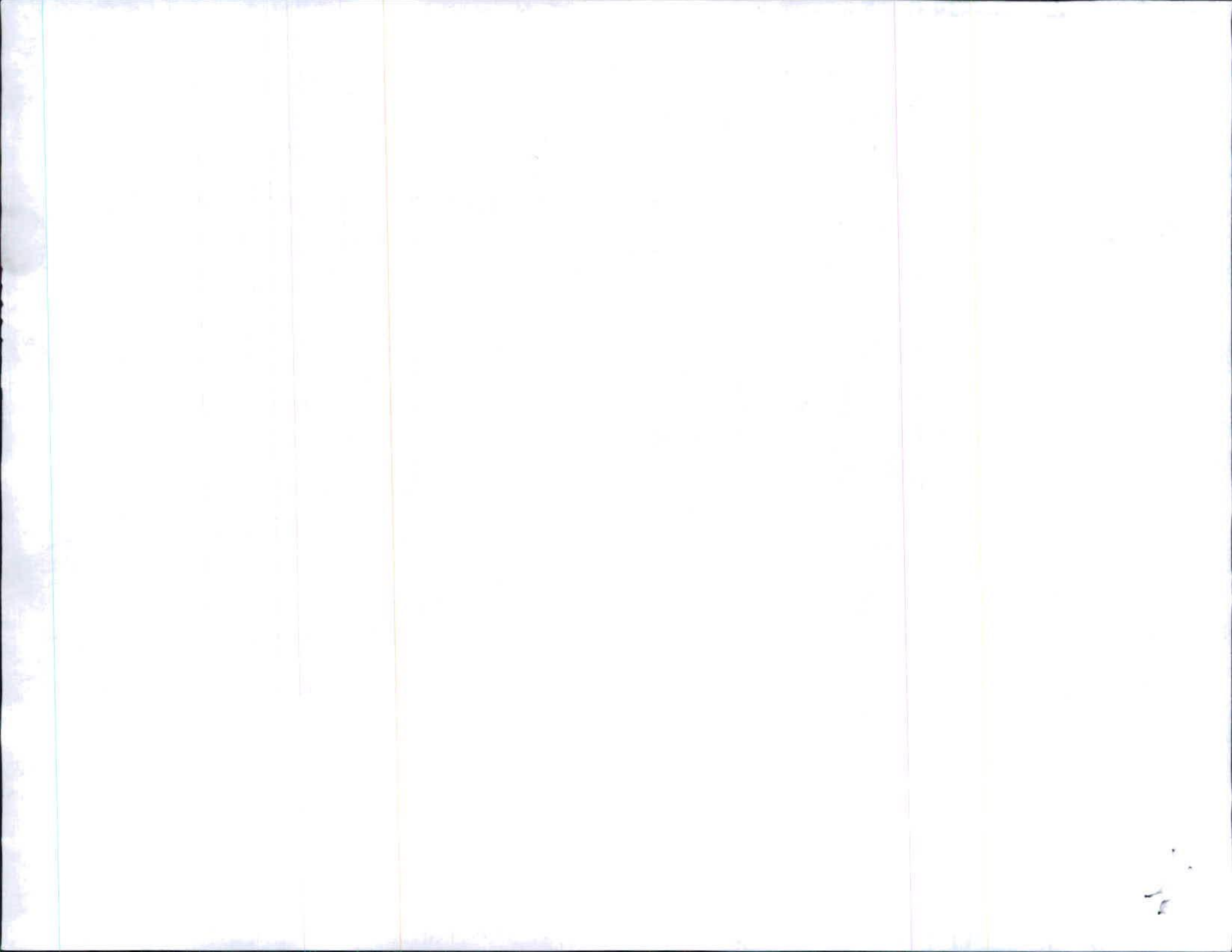
Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	74.4 : 74.5 (513 : 514)	62.9 : 63.2 (434 : 436)	11.8 : 12.1

(ASTM E1004)

Conductivity %IACS :	40.7 Min	41.0 Max
(MS/M) :	23.6 Min	23.8 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.16	1.5	0.02	2.5	0.20	5.7	0.03	0.01	0.01	TOT 0.05



**KAISER  
ALUMINUM**Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number  
4134429

Lot: 440545A2 Cast 170

Drop 22

Ingot 2

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.9 : 74.2 (510 : 512)	62.4 : 62.6 (430 : 432)	11.7 : 11.8

(ASTM E1004)

Conductivity %IACS :	40.6 Min	40.7 Max
(MS/M) :	23.5 Min	23.6 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.16	1.4	0.05	2.5	0.19	5.8	0.03	0.01	0.01	TOT 0.05

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**TEST NOTES**

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

**CASTLE METALS-LA**DATE REC'D 07/14/08REC'D FROM KAISERAPPROVED BY [Signature]IAC 6857**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR***Bill Poy*



